

Work Order ID 76169

76169

Page 1

Monday, November 07, 2011 12:58:56 PM

Item ID: D3278-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Assembly **35**
 Start Date: 11/7/2011 Start Qty: ~~40~~ ***40*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 11-11-07 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								

100 0.00
100 Small Fab
 Small Fab Memo 0.00
 Small Fab Rivet spacers with support as per Dwg D3278.

EP 11/11/08 **(35)**

110 0.00
110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

5 ululos

count
(35)

120 0.00
120 Small Fab
 Small Fab Memo 0.00
 Small Fab Assemble support as per Dwg D3278.***DO NOT TIGHTEN
 BOLTS***Identify as D3278-041

EP 11/11/09 **(35)**

35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76169

Monday, November 07, 2011 12:58:56 PM

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

[illegible]

R-1414
(35)

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Picklist Print

Monday, November 07, 2011 12:59:01 PM

Page 1

Work Order ID: 76169

76169

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1 *D3278-1* Support		Manufactured	No			100	Each	75.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				75					
				73412				35					
				74878				40					
D3278-2 *D3278-2* Support		Manufactured	No			100	Each	75.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				40					
				74879				40					
				GA				35					
				73413				35					
D3278-3 *D3278-3* Spacer		Manufactured	No			100	Each	75.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				75					
				70984				60					
				73414				15					

EB 11/11/08
34

EB 11/11/08
35

EB 11/11/08
16
19

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Purchased

No

100

Each

12,685.00

2

80

MS21042L 4

Nut

**

ES 11/11/09

Location

Loc Qty

Loc Code

ST300

1685

117441

51

117601

532

118451

133

118927

969

ST516

6000

119017

6000

ST518

5000

119075

5000

80

AN4-13A

Purchased

No

120

Each

1,451.000

2

80

AN4-13A

Bolt

**

ES 11/11/09

Location

Loc Qty

Loc Code

ST357

1451

118078

443

118706

8

118838

500

119449

500

80

AN960JD416

NAS1149D0463J Purchased

No

120

Each

0.0000

4

160

AN960JD416

Washer

**

4 M 11/9/09

160x

ES 11/11/09

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 40.00

Required Qty: 40.00

D2230-1 Manufactured No

120 Each 243.0000 2 80

D2230-1

Lug

**

EB 11/11/09

Location

Loc Qty

Loc Code

ST470	94
72811	94
ST476	149
67826	6
70974	3
73398	140

MS20426AD3-6 Purchased No

120 Each 3,205.0000 4 160

MS20426AD3-6

Rivet

**

EB 11/11/08

Location

Loc Qty

Loc Code

ST316	3205
105055	115
116289	3090

160

W/O:		WORK ORDER CHANGES					
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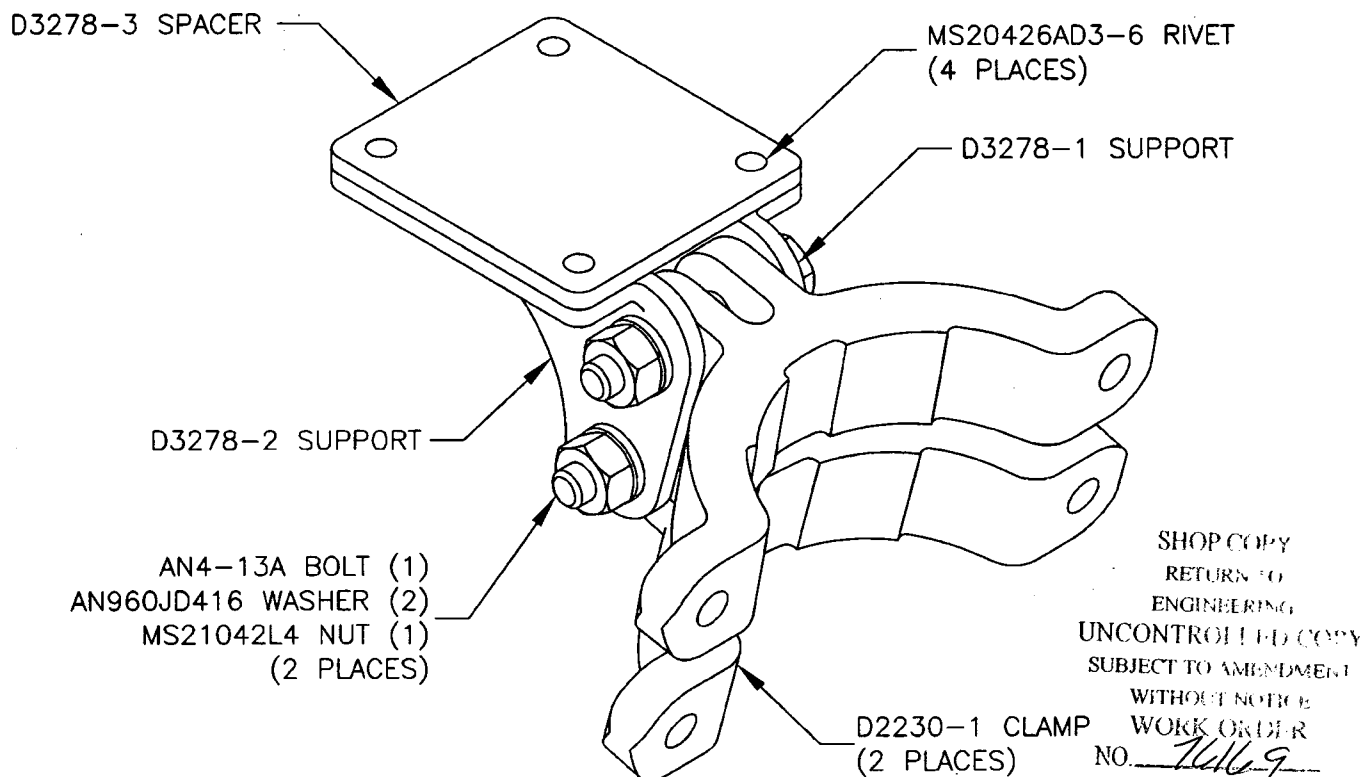
NOTE: Date & initial all entries

DART

DESIGN 97	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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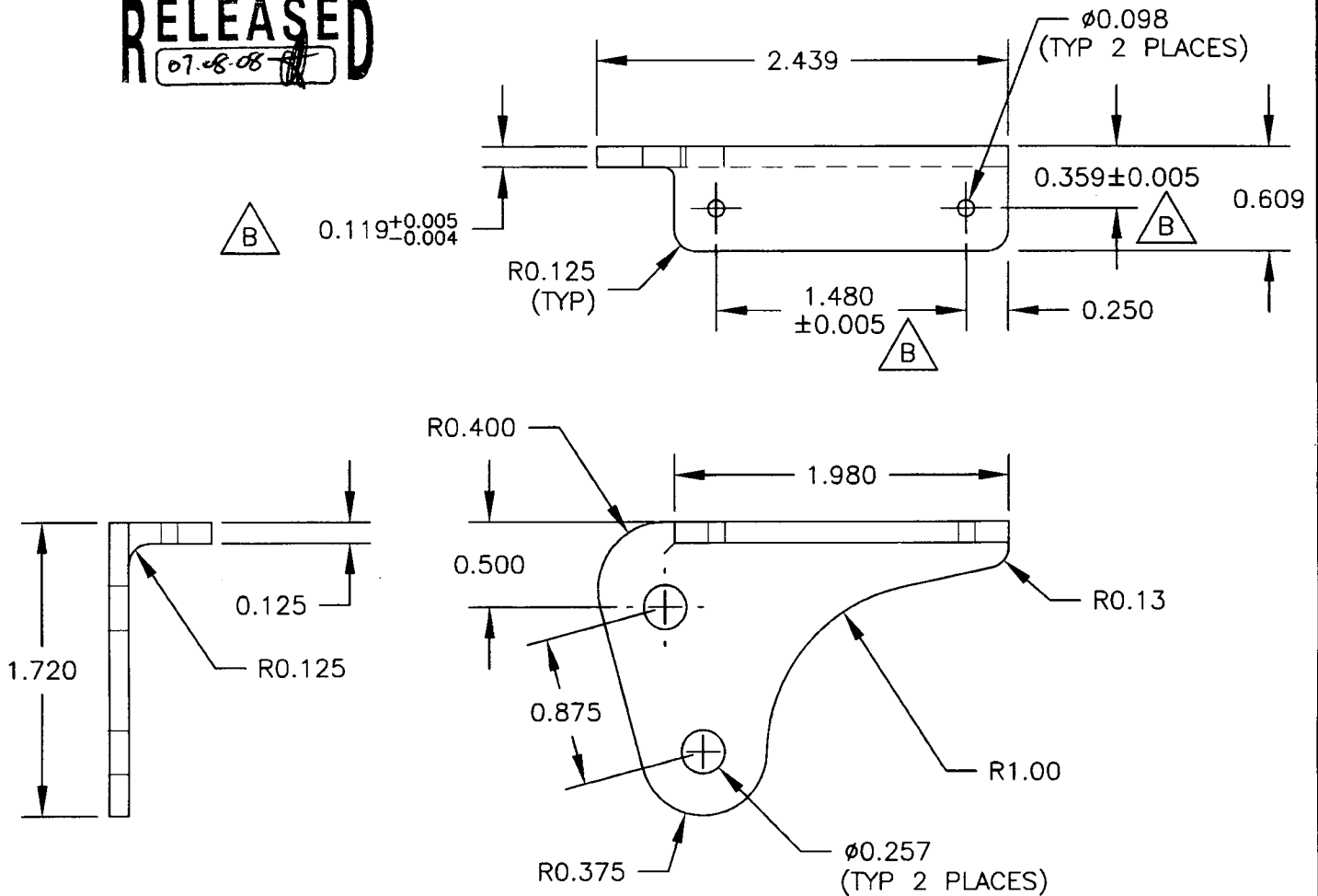
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DESIGN <i>gp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07-08-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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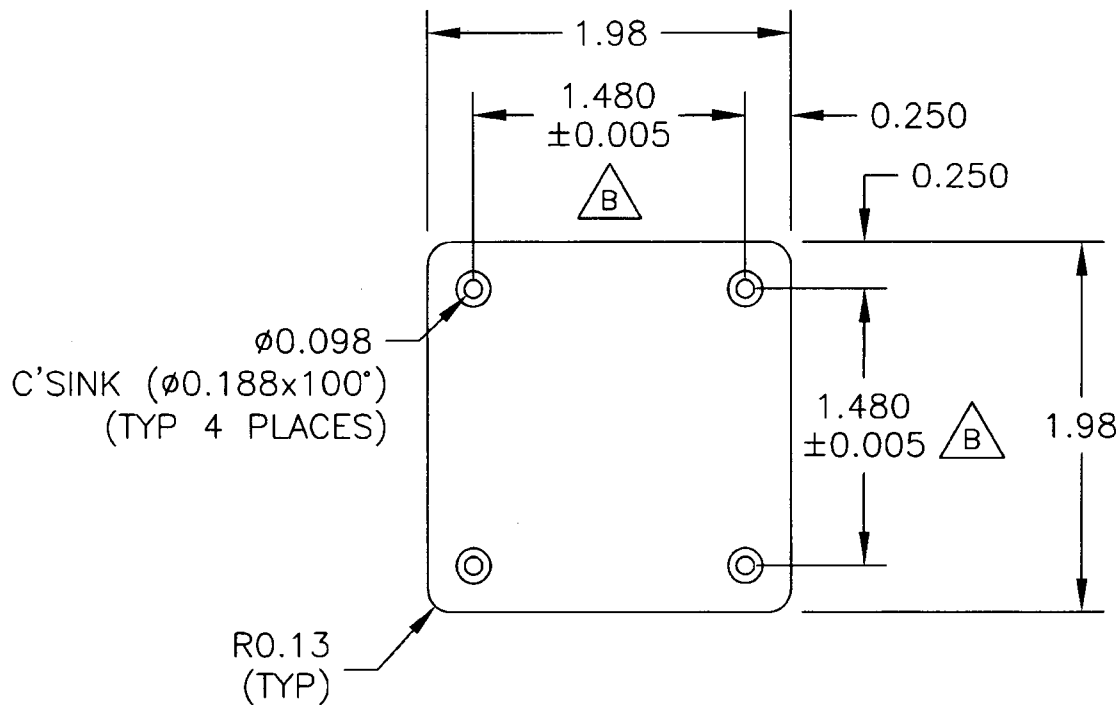
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DESIGN 9P	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED [Signature]	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



76169

D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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